



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2282-043
Job Sheet 214930



Part No: D2282-043

Job Qty: 25 pcs

Part Name: Saddle Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/3/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 12/25/20

Description: SIOP

Type: Stock

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Welded Assy-1	25 pcs	12/25/20		0.00	13.02	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	MV Nov 13/20
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
120	QC 9	25 pcs	12/25/20		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	DAS 50 11-17-20
							QC 9 - 50	
							QC 9 - 9	
160	Packaging 3-1 - Stock - B4B	25 pcs	12/25/20		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 11 - B4B	DAS 50 11-17-20
							Packaging 3 - 12 - B4B	



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Container No: S312726



Part: D2282-043

Job No: 214930

Serial No/Batch: S312726

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/20

Plex 11/3/20 11:28 AM Dart.Renwick.Jennife

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	25 pcs	12/25/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 9	21
				QC 21 - SA - 77	9-80
				QC 21 - SA - 28	

NOV 17 2020

Part Op **100** - Large Fab 1 (Weld per dwg A/R S.S. rod Batch: M19023) 1-Weld as per D2282-043 Saddle Assembly
 Descriptions: A/RER316L SS Filling Rod Dwg Rev: Grind weld with rough pad and brown pad, take all
 welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***
120 - QC9 (QC9- Inspect visual per QSI004- Fusion Welds)
160 - Packaging3 (Identify as per dwg & Stock Location:) LOCATION : GA 116
170 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2281	Jack Saddle	25 pcs (1 ea)	100-Large Fab - Welded Assy-1	5274564/5302444
D2282-7	Tube	50 pcs (2 ea)	100-Large Fab - Welded Assy-1	5246773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2281	25	28	0
	D2282-7	50	45	0

Part Specifications

Specifications could not be found.

Plex 11/3/20 11:28 AM Dart.Renwick.Jennifer

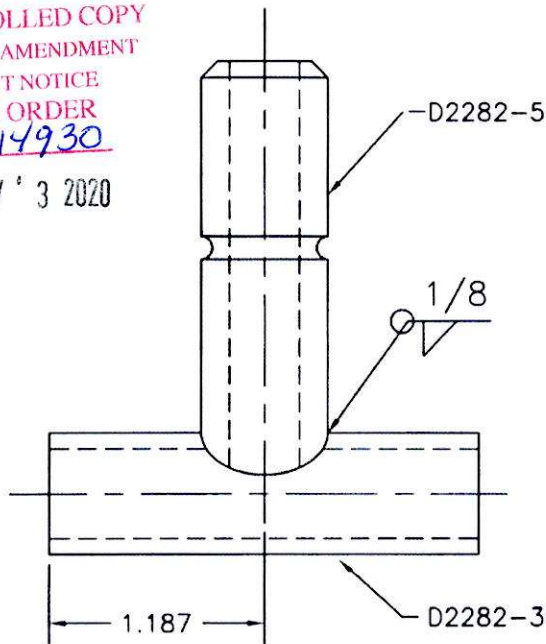


SHOP COPY
RETURN TO
ENGINEERING

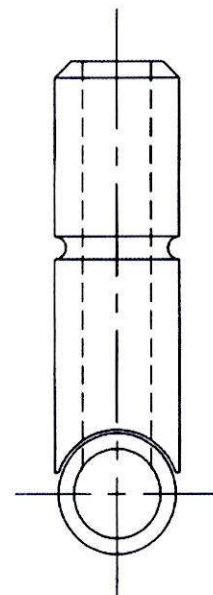
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 214930

NOV ' 3 2020

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



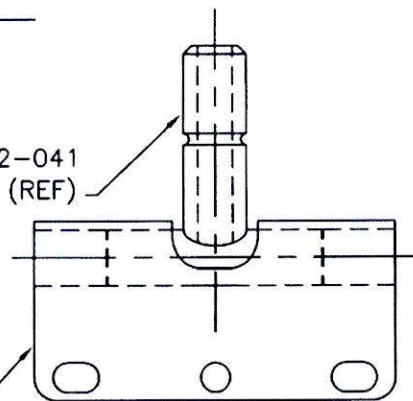
D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



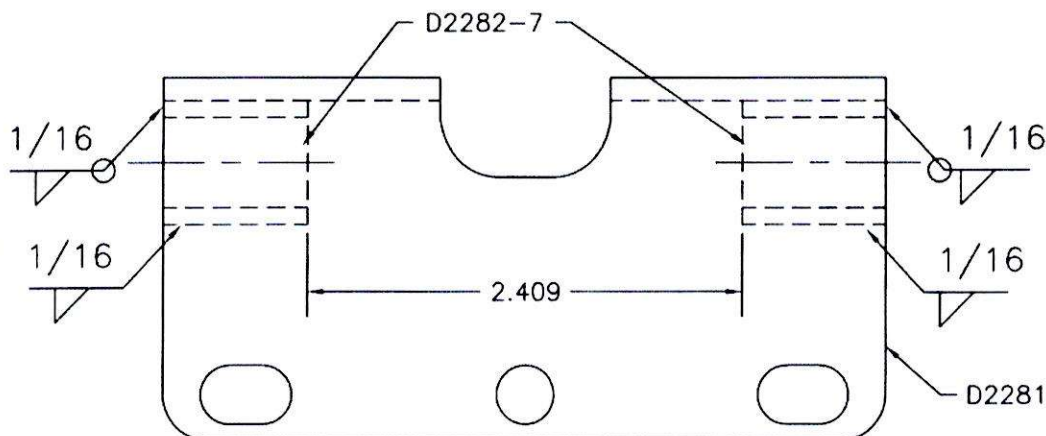
D2282-041
(REF)

DEO ATTACHED

D2282-043
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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DRAWING NO. D2282	TITLE HANDLE TUBES	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2282-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>dp</i>	CHECKED <i>M Lee</i>	MFG. APPR. <i>DP</i>	APPROVED <i>DP</i>		DE APPR. <i>N/A ON</i>		
DATE 17.02.24	DATE 17.06.22	DATE 17-6-22	DATE 2017.06.23		DATE <i>N/A ON</i>		

PURPOSE

CORRECT MATERIAL CALL-OUT TO ELIMINATE PIPE/TUBE CONFUSION (NCR16-5830)

CHANGE

MATERIAL CALL-OUT FOR D2282-3/-7 ON SHEET 1 IS UPDATED AS FOLLOWS:

IS:

D2282-3/-7 TUBE:

- 1) MATERIAL: Ø0.675 X 0.091 WALL SEAMLESS ROUND TUBING, TP304/TP316 STAINLESS STEEL PER ASTM A213 / A269 OR ASME SA213 / SA269
(REF. DART SPEC. M304TR0.675W0.091)
OR
3/8 SCHEDULE 40 SEAMLESS PIPE, TP304/TP316 STAINLESS STEEL PER ASTM A312 OR ASME SA312
(REF. DART SPEC. M304P0.675W0.091)

WAS:

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W0.091)

RELEASED

2017 JUN 26 *dp*
ECN 17-595

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			